

5/14

| | | |
|----------------------|--------------|---------|
| DART AEROSPACE LTD | Work Order: | 22746 |
| Description: Bracket | Part Number: | D3294-1 |
| Dwg: D3294 Rev. A | Qty: | 87 |
| Page 1 of 1 | | |

| Step | Location | Procedure | By | Date | Qty |
|------|----------|---|----|----------|-----|
| 1 | DC | Issue Traveler Note: To be made in multiples of 10 | KJ | 05.03.17 | 5 |
| 2 | MV | Cut blanks: 20.100" x 13.100" grain along 13.100" Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3294-1 Batch: M14646 | ED | 05/04/17 | 10 |
| 3 | MV | Machine as per Folio FA445 and Dwg D3294 Stack of 10 Identify as D3294-1 | EP | 05/04/17 | 10 |
| 4 | QC2 | Inspect parts as they come off the CNC machine | EP | 05/04/17 | 10 |
| 5 | QC8 | Second check | ML | 05/04/17 | 10 |
| 6 | GA | Deburr | FF | 05/04/17 | 9 |
| 7 | GA | Form as per Dwg D3294 | J | 05.05.09 | 267 |
| 8 | QC5 | Inspect work to Step 7 | IA | 05.05.10 | 157 |
| 9 | FP | Chemical Conversion Coat as per QSI 005 4.1 | FF | 05/05/10 | 7 |
| 10 | FP | Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3 | FF | 05/05/10 | 7 |
| 11 | QC3 | Inspect Powder Coat | M | 05 05 10 | 7 |
| 12 | ST | Identify and Stock | CL | 05/05/12 | 7 |
| 13 | AC | Cost / part 53.40 | SL | 05/05/13 | 7 |
| 14 | DC | Close W/O 39.10 Inspect Level 21 | HA | 05.06.06 | 7 |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|----------|
| A | 04.08.24 | New issue | KJ/JLM | |

RELEASED
04/08/20

| W/O: | | WORK ORDER CHANGES | | | | | | |
|----------|--------|---|--------------------|----------------------|-----|-------------------------------------|--------------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector | |
| 05/06/04 | # 3 | Change Dim. 13.00" on Dwg D3294 to 12.97" <i>Permanet Change</i> | <i>[Signature]</i> | 05.06.29 05.06.02 | N/A | <i>[Signature]</i> <i>Kerwin</i> | <i>[Signature]</i> 05-06-02 | |
| | | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|---|--------------------------------|--|--------------------------------|--------------------------------|--------------------------------|--------------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| 05-04-05 | 3 | Bur on edges are to thick to de bur, and holes not drilled all the way through Part from bottom of stack. | <i>[Signature]</i> 05-04-05 | Next time machine parts a little deeper Scrap & destroy | <i>[Signature]</i> 05-04-05 | <i>[Signature]</i> 05-04-05 | <i>[Signature]</i> 05-04-05 | <i>[Signature]</i> 05-04-05 |
| 05-05-05 | 8 | - one part bent on wrong side. - 1 CRACKED during bending | <i>[Signature]</i> 05-05-05 | - Scrap & destroy (x2) | <i>[Signature]</i> 05-05-05 | <i>[Signature]</i> 05-05-05 | <i>[Signature]</i> 05-05-05 | <i>[Signature]</i> 05-05-05 |
| | | | | | | | | |

Part No: D3294-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: *[Signature]* Date: 05/06/03
 NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

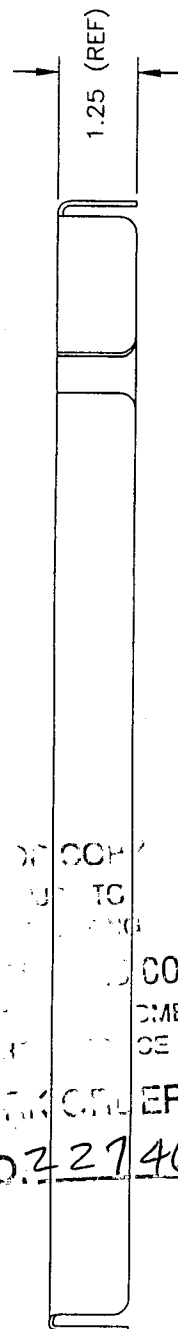
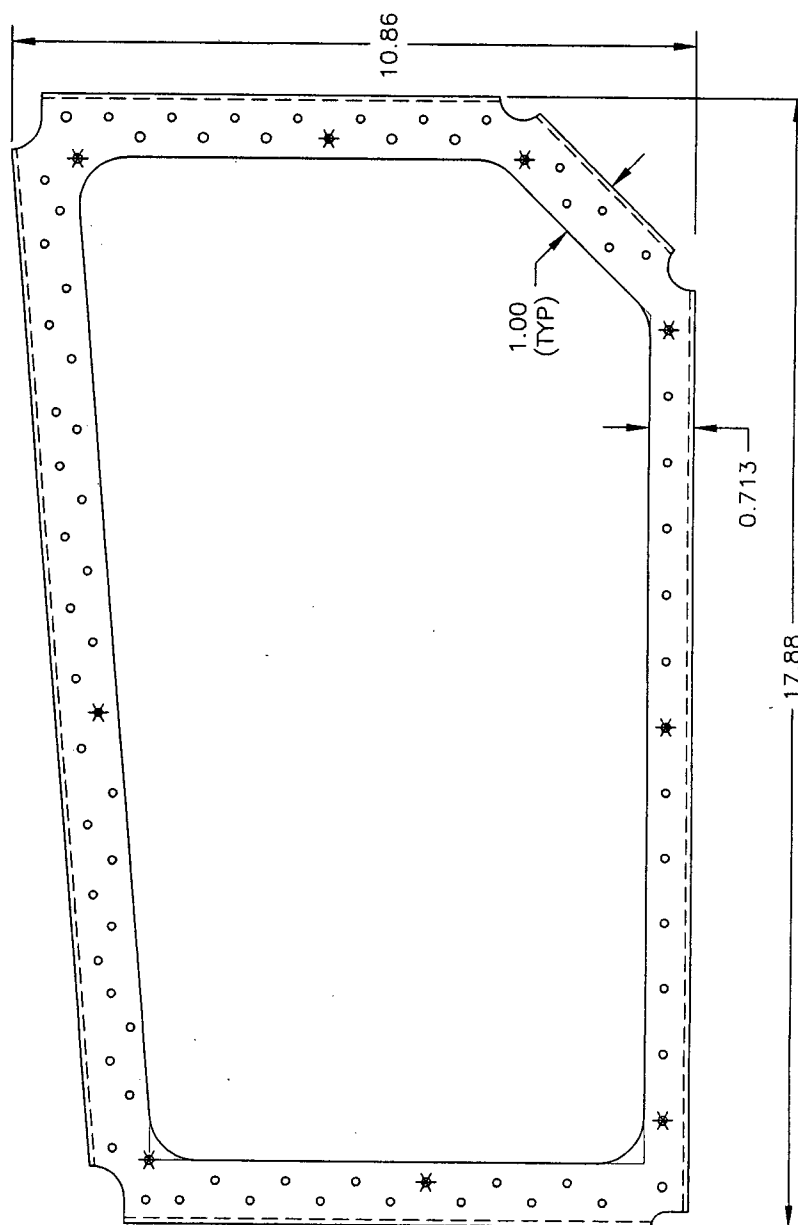


| | | | |
|-------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3294 | REV. A SHEET 1 OF 2 |
| DATE 04.06.28 | | TITLE BRACKET | SCALE 1:3 |
| A | 04.06.28 | NEW ISSUE | |

RELEASED
04.07.12

D3294-1 BRACKET

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



COPY
TO
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MENT
CE
WORK ORDER
NO. 22746

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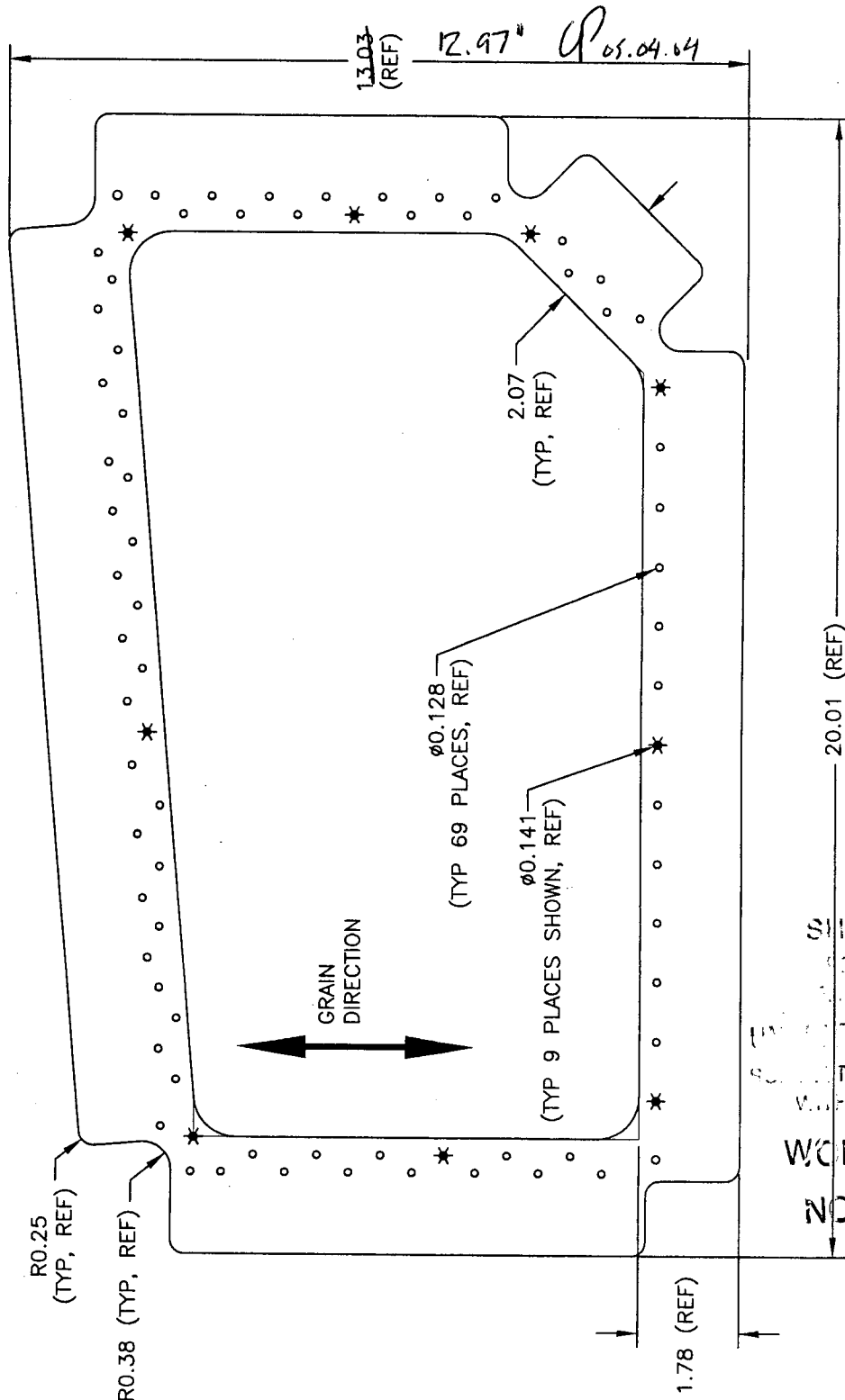
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| | | | |
|---------------------|-----------------------|---|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>H</i> | APPROVED <i>H</i> | DRAWING NO. D3294 | REV. A SHEET 2 OF 2 |
| DATE 04.06.28 | TITLE BRACKET | | SCALE 1:3 |

D3294-1 FLAT PATTERN

RELEASED
R 04.07.12



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WORK ORDER
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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 16, 2005
02:16 pm

Work Order No : 0022746
Project Name : D3294-1
Project For : WK514
Work Order Type : Main
Main WO Number :
House Part Number : D3294-1
Description : Bracket
Manufactured : Yes
Amount Req'd : 5
Amount Done : 0
Start Date : 03-16-05
Est Finish Date : 04-12-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Mark up : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | Estimated | Actual |
|--------------------------|-----------|--------|
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |